

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007221**Date Inspected:** 22-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG and Tower Fabrication**Summary of Items Observed:**

CWI Inspectors: Mr. Li Jia. Mr. Wu Zh Feng, Mr. Li Hong Fei

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Tower Bay 11

The QA Inspector observed ZPMC welder Mr. Zhong Cheng, stencil 041271 is using welding procedure specification WPS-B-T-4211-B-U3b-2 to complete shielded metal arc weld WSD1-FASA4-2A/B-4B. The QA Inspector observed that the base material where weld was made had been preheated to above 160 degrees Celsius and a ZPMC QC Inspector is monitoring this welding. The QA Inspector measured a welding current of approximately 240 amps and the welding electrodes are being stored in a heated container. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

Tower Bay 10

The QA Inspector observed ZPMC welder Mr. Jiang Guo, stencil 204202 is using the shielded metal arc process to weld run off plates on the end of weld ESD1-FASA4-2A/C-3A. The QA Inspector observed that the base material where the weld was made had been preheated to above 110 degrees Celsius and a ZPMC QC Inspector is

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monitoring this welding. QA Inspector measured a welding current of approximately 170 amps and the welding electrodes are being stored in a heated container. Items observed by this QA Inspector appear to be progressing in compliance with project specifications.

OBG Bay 7

The QA Inspector observed ZPMC welder Mr. Jin Anquan, stencil 201725 is using shielded metal arc process WPS-B-P-2112-FCM to make fillet tack welds on OBG Side Plate stiffener weld SP202-015-003. The QA Inspector observed a welding current of approximately 160 amps, the welding electrodes are being stored in a heated container, the base materials are being preheated to a minimum of 110 degrees Celsius and a ZPMC QC Inspector is monitoring the welding and preheating of the base material. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Mr. Xiao Di, stencil 203204 is using shielded metal arc process WPS-B-P-2112 to make fillet tack welds on OBG Side Plate stiffener weld SP204-016-003. The QA Inspector observed a welding current of approximately 155 amps, the welding electrodes are being stored in a heated container and a ZPMC QC Inspector is monitoring the welding. Items observed by the QA Inspector appear to comply with project specifications.

The QA Inspector observed ZPMC welder Mr. Xv Xiujun, stencil 215259 is using shielded metal arc process WPS-B-P-2112 to make fillet tack welds on OBG Side Plate stiffener weld SP203-016-005. The QA Inspector observed a welding current of approximately 160 amps, the welding electrodes are being stored in a heated container and a ZPMC QC Inspector is monitoring the welding. Items observed by the QA Inspector appear to comply with project specifications.

Summary of Conversations:

See above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang phone: 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
